

# Work Order ID 53125

October 22, 2009 4:23:24 PM



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Item ID: D2893-1  
 Revision ID: B  
 Item Name: 2.75 Support  
 Start Date: 23/11/2009 Stz Qty: 20.00  
 Required Date: 23/11/2009 Req'd Qty: 20.00  
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: PL Date: 09-10-22 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2893	Rev B

100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo Machine as per Folio FA081 Tumble & Deburr								

SL/mf 09/11/08

19 01

710

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								

SL/mf 09/11/08

19 01

120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
Quality Control	Memo								

SL 09/11/09

19 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2893-1 PAR #: \_\_\_\_\_ Fault Category: Machined parts NCR: (Yes) No DQA: \_\_\_\_\_ Date: 05-11-30  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: 05-11-30

NCR: 53125		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/11/06</u>	<u>100</u>	<u>1 part 2893-1 tool pulled out of holder while machining causing deep grooves in part 2nd half</u>	<u>CP</u> <u>05.11.06</u> <u>pc</u> <u>05/10/12</u>	<u>Thickness of affected area 20.100". Acceptable</u> <u>2nd part Scrap. (unrepaired)</u>	<u>SL</u> <u>09/11/06</u>	<u>OK</u> <u>09/11/09</u>	<u>CP</u> <u>05.11.06</u> <u>pc</u> <u>05/10/12</u>	<u>05-11-05</u>
		<u>has only minor grooves, is part acceptable?</u> <u>R.C. process</u>	<u>[Signature]</u> <u>05/10/12</u>					

NOTE: Date & initial all entries

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Item ID:	D2893-1	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	2.75 Support					
Start Date:	23/11/2009	Start Qty: 20.00		Cust Item ID:		
Required Date:	23/11/2009	Req'd Qty: 20.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	M112148								
Powdercoat	Memo	0.00							
Powder Coating	Mask Inside Bore for Primming <input type="checkbox"/> START TIME: 7:00AM <input type="checkbox"/> OVEN TEMPERATURE: 7:30AM <input type="checkbox"/> FINISH TIME: 4:00PM								

140	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

150	SprayPaint	0.00							
SprayPaint	Memo	0.00							
Spray Painting	Prime inside surface as per Dwg D2893 and QSI 005 4.3								

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Item ID: D2893-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: 2.75 Support

Start Date: 23/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 23/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

09-11-24

19

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

m/

09

11

24 19

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/25

m/ 09-11-24

# Picklist Print

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Work Order ID: 53125



Parent Item: D2893-1RevB



Parent Item Name: 2.75 Support

Start Date: 23/11/2009

Required Date: 23/11/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSK078RevA		Manufactured	No			100	Each	25.0000	10.0000			
D2893-1 TURNING DETAIL												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	25	
47395	5	
47975	10	
51879	10	

10 JK 09/11/05

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	03125
<b>Description:</b> Ø2.750 Support		<b>Part Number:</b>	D2893-1
<b>Inspection Dwg:</b> D2893		<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.987	2.986	2.994	2.994	2.994
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.143	.143	.146	.143	.143
AD	0.040	0.060		.049	.049	.049	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.142	.142	.142	.140	.141
AG	0.140	0.160		.156	.155	.156	.154	.156
AH	1.360	1.400		1.366	1.366	1.371	1.372	1.368
AI	0.040	0.060		.053	.047	.056	.047	.049
AJ	1.190	1.230		1.208	1.208	1.209	1.209	1.208
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.522	2.523	2.523	2.521	2.525
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b>	JL	<b>Date:</b>	09/11/06
<b>Audited by:</b>	SMX	<b>Date:</b>	09/11/09
<b>Prototype Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

0252

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53125
<b>Description: Ø2.750 Support</b>		<b>Part Number:</b>	D2893-1
<b>Inspection Dwg: D2893</b>		<b>Rev: B</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#9	#10
<b>HAAS Section</b>								
AA	2.985	3.005		2.996	2.997	2.997	2.995	2.991
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.140	.141	.142	.140	.140
AD	0.040	0.060		.050	.050	.052	.049	.049
AE	0.188	0.193		.191	.191	.192	.192	.191
AF	0.125	0.160		.137	.140	.140	.140	.140
AG	0.140	0.160		.151	.150	.151	.152	.153
AH	1.360	1.400		1.373	1.375	1.377	1.373	1.375
AI	0.040	0.060		.050	.053	.052	.051	.050
AJ	1.190	1.230		1.211	1.220	1.219	1.215	1.216
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.523	2.530	2.533	2.533	2.537
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.263	.265	.265	.264	.264
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
<b>Accept/Reject</b>								

**Measured by:** MAF
**Date:** 09/11/08

**Audited by:** SM
**Date:** 09/11/09

**Prototype Approval:** \_\_\_\_\_
 **Date:** \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53125
<b>Description: Ø2.750 Support</b>		<b>Part Number:</b>	D2893-1
<b>Inspection Dwg: D2893</b>		<b>Rev: B</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
<b>HAAS Section</b>								
AA	2.985	3.005		2.994	2.993	2.995	2.995	2.994
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.142	.139	.140	.141	.140
AD	0.040	0.060		.051	.051	.052	.050	.054
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.141	.140	.136	.138	.140
AG	0.140	0.160		.153	.151	.152	.152	.152
AH	1.360	1.400		1.372	1.379	1.372	1.373	1.372
AI	0.040	0.060		.053	.052	.053	.052	.050
AJ	1.190	1.230		1.217	1.210	1.215	1.217	1.213
AK	0.010	0.020		.015	.05	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.525	2.528	1.538	1.536	1.538
AO	84.39	90.39	<del>87.39</del>	87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.265	.265	.265	.265	.264
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
<b>Accept/Reject</b>								

<b>Measured by:</b> <i>mmf</i>	<b>Date:</b> 09/11/08
<b>Audited by:</b> <i>mmf</i>	<b>Date:</b> 09/11/09
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53125
<b>Description: Ø2.750 Support</b>		<b>Part Number:</b>	D2893-1
<b>Inspection Dwg: D2893</b>	<b>Rev: B</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	#17	318	419	520
HAAS Section								
AA	2.985	3.005		2.992	2.994	2.996	2.994	
AB	0.440	0.460		.440	.440	.440	.440	
AC	0.125	0.160		.140	.138	.140	.141	
AD	0.040	0.060		.051	.050	.050	.051	
AE	0.188	0.193		.191	.191	.191	.191	
AF	0.125	0.160		.140	.138	.138	.140	
AG	0.140	0.160		.152	.150	.151	.151	
AH	1.360	1.400		1.372	1.376	1.372	1.375	
AI	0.040	0.060		.054	.054	.053	.053	
AJ	1.190	1.230		1.217	1.222	1.217	1.218	
AK	0.010	0.020		.015	.015	.015	.015	
AL	0.053	0.073		.063	.063	.063	.063	
AM	0.240	0.260		.250	.250	.250	.250	
AN	2.518	2.538		2.537	2.537	2.538	2.538	
AO	84.39	90.39		87.39	87.39	87.39	87.39	
AP	0.261	0.266		.265	.263	.264	.263	
AQ	0.053	0.073		.063	.063	.063	.063	
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b>	mde	<b>Date:</b>	09/11/08
<b>Audited by:</b>	ml	<b>Date:</b>	09/11/09
<b>Prototype Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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